

Date: Friday, 9/21/2007 12:59:46 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	206/OH-58 SADDLE, OUTBOARD, LEFT SIDE		
Job Number	34783					
Estimate Number	10831					
P.O. Number	N/A		Part Number	D29321		
This Issue	9/21/2007	S.O. No. : N/A	Drawing Number	D2932 REV C		
Prsh Rev.	NC		Project Number	N/A		
First Issue	N/A	Type : MACHINED PARTS	Drawing Revision	C		
Previous Run	34615		Material	N/A		
Written By			Due Date	10/10/2007 Qty: 6 Um: Each		
Checked & Approved By	<i>JLM 07.09.24</i>					
Comment	Est: B00.06.26 New DWG rev, (mpp 2069) EC Est Rev:C As per Rev C 07-03-19 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101003	7075-T7351 2X6.25X7.875	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) 7075-T7351 2X6.25X7.875 Issue material from stock: 7075-T7351 Cut Size 2.0 x 6.25 X 7.880 Grain Along Long 7.88 Length Batch No: <i>B31644</i>	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 5-Deburr & TUMBLE	<i>SG 07.10.04 (6)</i>
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet	<i>SG 07.10.04 (6)</i>
4.0	QC1	INSPECT ALL DIM TO DIM SHEET	
		Comment: INSPECT ALL DIM TO DIM SHEET	<i>SG 07.10.04 (6)</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 01/10/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/21/2007 12:59:46 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE

Job Number: 34783

Part Number: D29321

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

8/8 07/10/05 (6)

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-H

07/10/09

7.0 POWDER COATING POWDER COATING



M105068

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

4/07-10-10

(6X)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

P-7110-10 (6)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

STG28

6/11/10 (6)

(6)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10/11/11

Job Completion



u 8/10/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	34783
Description: 206 Saddle, Outboard, Left side				Part Number:	D2932-1
Inspection Dwg: D2932 Rev. C				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.125	.125	.125	.125		
B	0.100	0.140		.125	.125	.125	.125		
C	0.100	0.140		.130	.130	.130	.130		
D	0.210	0.230		.124	.124	.124	.124		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		.239	.239	.239	.239		
N	0.100	0.140		.125	.125	.125	.125		
O	0.540	0.560		.548	.548	.548	.548		
P	0.490	0.510		.501	.501	.501	.501		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.495	2.495	2.495	2.495		
S	0.240	0.270		.260	.260	.260	.260		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.319	.319	.319	.319		
X	1.125	1.145		1.132	1.135	1.136	1.136		
Y	1.565	1.585		1.567	1.570	1.570	1.570		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SG	Audited by:	
Date:	07.10.04	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	SG

DART AEROSPACE LTD	Work Order:	34783
Description: 206 Saddle, Outboard, Left side	Part Number:	D2932-1
Inspection Dwg: D2932 Rev. C		Page 1 of 1

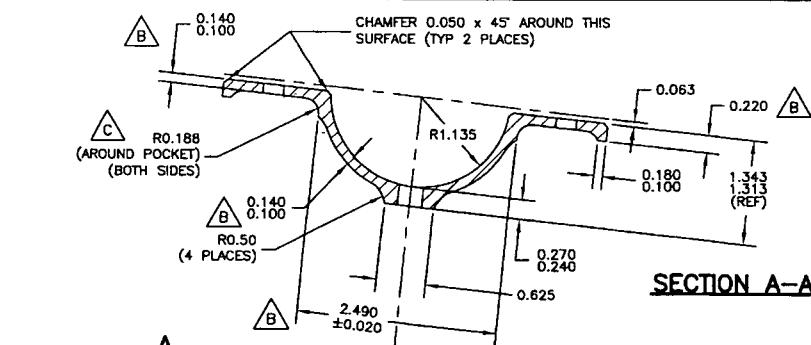
Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.123	.123				
B	0.100	0.140		.122	.122				
C	0.100	0.140		.117	.117				
D	0.210	0.230		.225	.225				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.510	.510				
I	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		.254	.258				
L	0.312	0.317		.314	.314				
M	0.235	0.240		.239	.239				
N	0.100	0.140		.127	.127				
O	0.540	0.560		.550	.550				
P	0.490	0.510		.504	.504				
Q	3.715	3.725		3.720	3.720				
R	2.470	2.510		2.495	2.495				
S	0.240	0.270		.253	.253				
T	0.100	0.180		.140	.140				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321		.319	.319				
X	1.125	1.145		1.135	1.135				
Y	1.565	1.585		1.575	1.575				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									

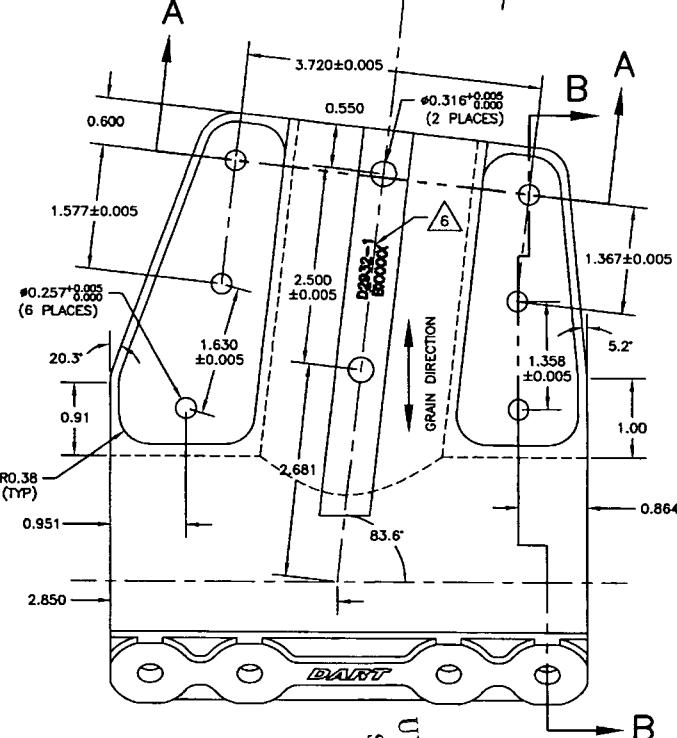
Accept/Reject

Measured by:	<i>SG</i>	Audited by:	
Date:	07.10.04	Date:	

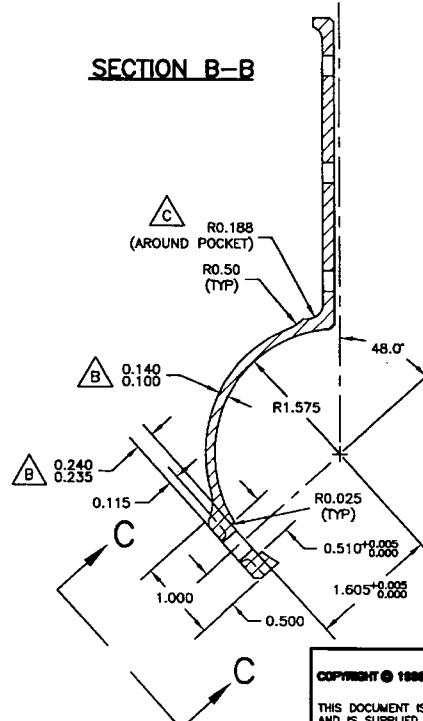
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM <i>KJ</i>	<i>SPD</i>



SECTION A-A



SECTION B-B



VIEW C-C

D2932-1 LH SADDLE (SHOWN)
D2932-2 RH SADDLE (OPPOSITE)

NOTES

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MADE FROM D6101-003 SADDLE BILLET, 7075)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
3) BREAK ALL SHARP EDGES 0.010 TO 0.020
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
5) ALL DIMENSIONS ARE IN INCHES
6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	RO.188 WAS RO.30 TO RO.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN <i>4</i>	DRAWN BY <i>CB</i>	DART DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED <i>Pt</i>	APPROVED <i>✓</i>	DRAWING NO. D2932 REV. C SHEET 1 OF 1
DATE 06.11.09	TITLE SADDLE OUTSIDE SCALE 2-3	